

# Work Order ID 82386

\*82386\*

Page 1

March-30-12 7:46:29 AM

Item ID: D2666-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle, LH Fwd Aft In 206

Start Date: 29/03/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/30

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2666	Rev D								

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

FK. 12/06/25

10

Ø

HAAS CNC vertical machine #1

Program batch number.1- Inspect part number and batch number are programmed correctly.2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

PD 12/06/26

110

0.00

\*110\*

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

PD

12/06/27

10

Ø

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

FK. 12/06/25

PD 12/06/26

10

Ø

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82386

March-30-12 7:46:29 AM

**\*82386\***



Page 2

Item ID: D2666-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Saddle, LH Fwd Aft In 206  
 Start Date: 29/03/2012      Start Qty: 4.00      **\*4\***      Cust Item ID:  
 Required Date: 12/04/2012      Req'd Qty: 4.00      **\*4\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	SL	12-06					
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				10	12-6-28		
150 <b>*150*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 7h05 320°F FINISH TIME: 7h35	0.00 0.00				10	12/06/19.		
									OVEN TEMPERATURE: M120 222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82386

March-30-12 7:46:29 AM

**\*82386\***

Page 3

Item ID: D2666-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, LH Fwd Aft In 206  
 Start Date: 29/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/04/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

10 0 12/12/3.

P 12/7/03 (10)

12/7/4

ME  
12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-30-12 7:46:33 AM

Page 1

Work Order ID: 82386

\*82386\*

Parent Item: D2666-1

\*D2666-1\*

Parent Item Name: Saddle, LH Fwd Aft In 206

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	27.0000	1	4			

\*D6101-001\*

Saddle Billet

\*\*

Location

Loc Qty

Loc Code

MAT040

3

69677

2

76836

1

MAT041

24

80764

24

85433

10

FK 12/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 82386	
<b>Description:</b> 206 Saddle, Inboard, Left side				<b>Part Number:</b> D2666-1	
<b>Inspection Dwg:</b> D2666 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.123	.123	.122	0.119	0.118
B	0.100	0.140		.103	.106	.106	0.105	0.105
C	2.470	2.510		2.492	2.492	2.492	2.492	2.490
D	0.100	0.180		.135	.135	.135	0.135	0.135
E	0.210	0.230		.222	.223	.223	0.215	0.217
F	1.313	1.343		1.325	1.325	1.325	1.321	1.321
G	0.240	0.260		.258	.253	.253	0.251	0.251
H	0.615	0.685		.627	.635	.635	0.635	0.635
I	1.125	1.145		1.129	1.135	1.135	1.135	1.135
J	0.990	1.010		1.006	1.002	1.002	1.003	1.003
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238
L	0.510	0.515		0.512	0.512	0.512	0.512	0.512
M	0.100	0.120		0.110	0.110	0.110	0.110	0.110
N	1.565	1.585		1.569	1.573	1.574	1.574	1.574
O	5.990	6.010		6.000	5.998	5.998	5.998	5.998
P	1.245	1.255		1.250	1.250	1.250	1.249	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		.498	.498	.498	0.497	0.497
S	0.312	0.318		.314	.314	.314	0.313	0.314
T	2.495	2.505		2.500	2.500	2.500	2.500	2.499
U	1.357	1.367		1.362	1.362	1.362	1.362	1.361
V	0.315	0.322		.316	.316	.316	0.317	0.317
W	0.540	0.560		.550	.550	.550	0.547	0.547
X	1.674	1.684		1.679	1.679	1.679	1.678	1.679
Y	0.256	0.262		.258	.258	.258	0.258	0.259
Z	0.178	0.198		.188	.188	.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> F.K.	<b>Date:</b> 12/06/25
<b>Audited by:</b> J.S.	<b>Date:</b> 12-06-28
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	M

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82386
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b>	D2666-1
<b>Inspection Dwg:</b> D2666 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>		Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1 6	2 7	3 8	4 9	5 10
A	0.100	0.140		0.118	0.118	0.118	0.121	0.121
B	0.100	0.140		0.104	0.104	0.104	0.103	0.101
C	2.470	2.510		2.491	2.490	2.490	2.490	2.490
D	0.100	0.180		0.135	0.135	0.135	0.135	0.135
E	0.210	0.230		0.217	0.217	0.220	0.218	0.220
F	1.313	1.343		1.322	1.320	1.324	1.322	1.322
G	0.240	0.260		0.252	0.252	0.250	0.250	0.253
H	0.615	0.685		0.635	0.635	0.635	0.635	0.635
I	1.125	1.145		1.132	1.135	1.139	1.136	1.137
J	0.990	1.010		1.003	1.003	1.003	1.003	1.003
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238
L	0.510	0.515		0.512	0.512	0.512	0.512	0.512
M	0.100	0.120		0.110	0.110	0.110	0.110	0.110
N	1.565	1.585		1.570	1.574	1.576	1.575	1.575
O	5.990	6.010		5.997	5.998	5.998	5.998	5.998
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		0.496	0.496	0.498	0.497	0.499
S	0.312	0.318		0.314	0.314	0.314	0.314	0.314
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.363	1.362	1.362	1.362	1.362
V	0.315	0.322		0.317	0.317	0.317	0.317	0.317
W	0.540	0.560		0.548	0.548	0.548	0.547	0.549
X	1.674	1.684		1.678	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> PO	<b>Date:</b> 12/06/26
<b>Audited by:</b> SL	<b>Date:</b> 12-06-28
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	M

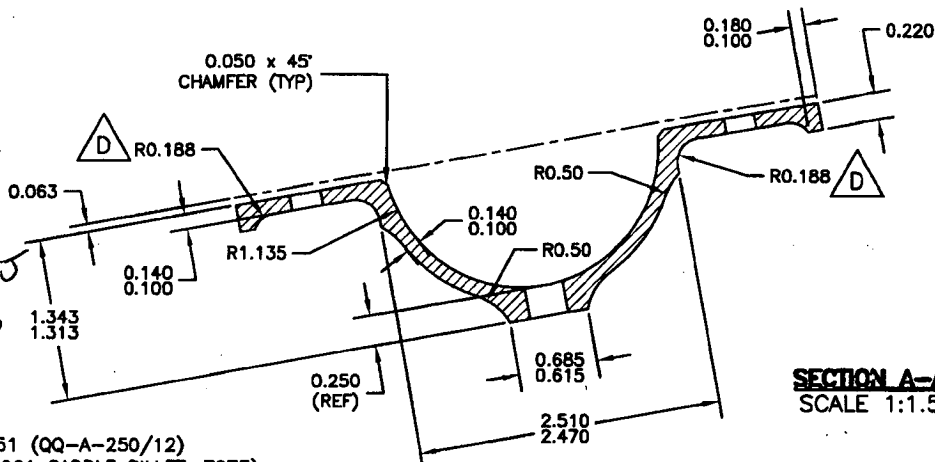


DESIGN <b>#</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

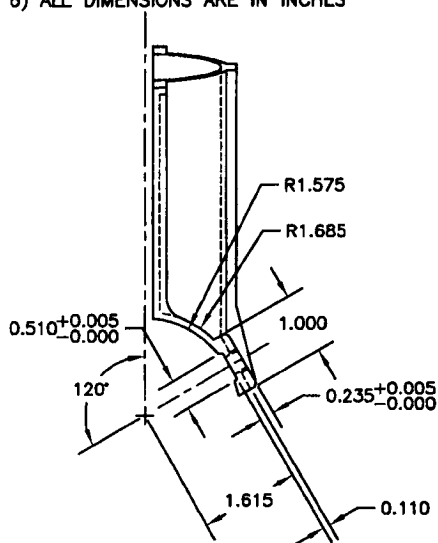
07 02 12 **#**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **82386 MWS**  
**12/03/30**

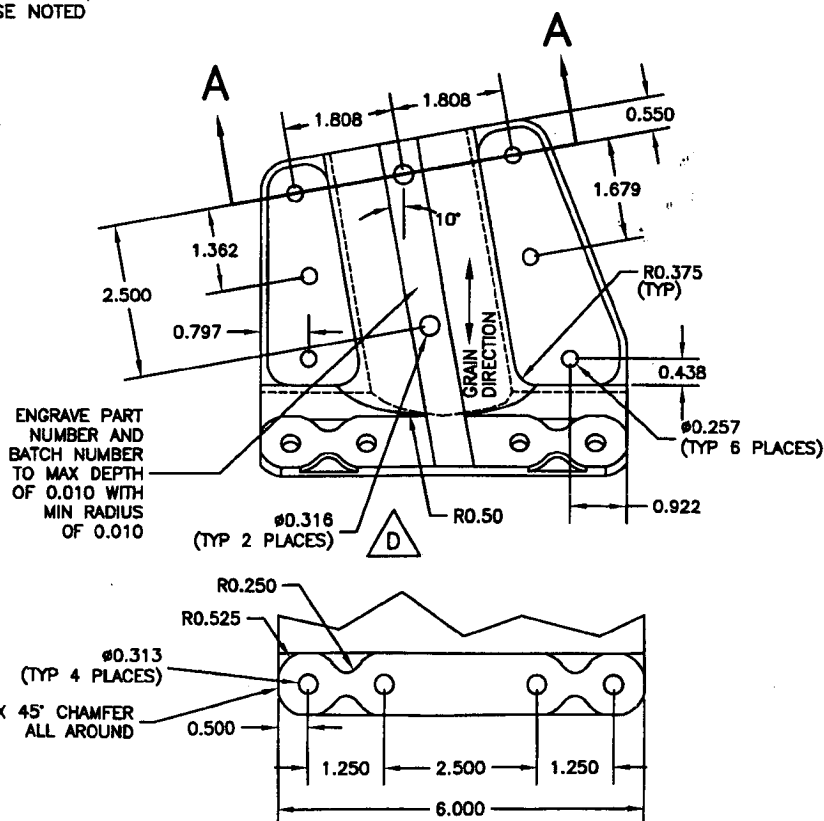


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



**D2666-1 SADDLE FWD INSIDE HIGH**



Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.